

20-8387



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POSITIVE RECALL

EFFECTIVE 20/08/12 AUTH SAZ
RELEASED 9 DATE 20-08-12
9-89



D3144-115

Job Sheet 212138



Part No: D3144-115

Job Qty: 1 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/11/20

Job Tracking No:

Due Date: 8/12/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP A 04.11.29 New issue KJ/RF

Ship Via:

Bill of Materials

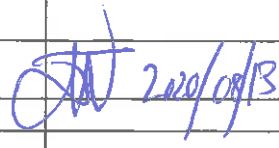
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		8/11/20	0.17	0.14	Waterjet - Flow		OK 20/08/12
110	QC 2	1 pcs		8/11/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 20/08/12
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 8/11/20 8:29 AM Dart.Renwick.Jennifer

120	QC 8	1 pcs	8/11/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
140	Handfinish - 1-1 Chemical- B4B	1 pcs	8/11/20	0.00 0.03	QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 -	

DAS
40
9-89
AUG 12 2020

				B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 4 Black Sand - B4B	1 pcs	8/12/20	0.00 0.01	Powdercoat - 1 - B4B	 20-08-13
M 156440 START: 11:45 O.V.T: 300° FINISH: 12:15				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	1 pcs	8/12/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	AUG 13 2020
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
170 Packaging 3-1 - Stock - B4B	1 pcs	8/12/20	0.00 0.00	Packaging 3 - 1 - B4B	N/A AUG 18 2020
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

Not used per SP 20.08.18 SAY 2.10.18/18 DAS 51 9.39			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 37 - B4B		
180 QC 21 - SA	1 pcs	8/12/20	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 9 QC 21 - SA - 77	DAS 21 9.39 AUG 18 2020
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) Location : CA2 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item M2024T3S.032	Component Name 2024-T3 .032 Sheet	Quantity .2000 sf (.2 ea)	Operation 100-Waterjet - Flow - 1	Container S101799	
Job Allocations					
Operation 100-Waterjet - Flow - 1	Component Part M2024T3S.032	Required 0	Inventory 73	Allocated 0	
Part Specifications					
Specifications could not be found.					

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Container No: S293637



Part: D3144-115

Job No: 212138

Serial No/Batch: S293637

Revision:

Inspector:

Exp Date:

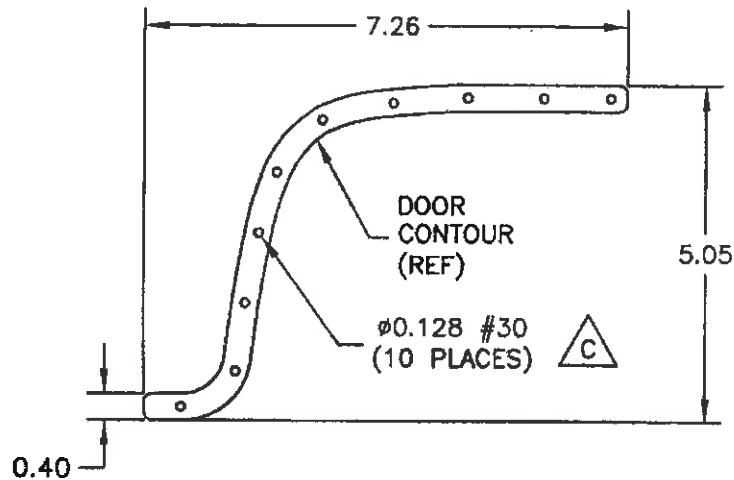
Instructions: Various STC's

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www.dartaerospace.com

Date: 08/12/20



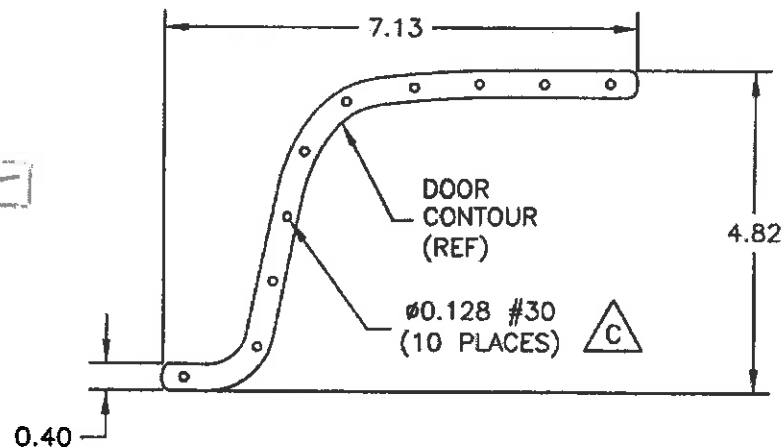
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3144	REV. C SHEET 8 OF 9
DATE 05.10.19	TITLE DOUBLER		SCALE NTS



D3144-109 DOUBLER (FOR D412-694-01)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212138

RELEASED
05.11.14 *[Signature]*



D3144-115 DOUBLER (FOR D412-694-02)

D3144-109/-115 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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Entered:

Date: **AUG 27 2020**



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8387

Route update only

Job: <u>212138</u>		DISPOSITION		DEPARTMENT/PROCESS					
Part No. <u>D3144-115</u>		Rework ☒ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>AUG 12 2020</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>			MRB (QSI042) <u>Sam</u> <u>20/08/12</u>		
Description Work Order Deviation				Disposition				Completed By <u>on 20/08/12</u>	
Substitut Mat thickness to correspond to the space door gap S/N 193543 and S/N 193545				Asapha				Lead hand / Supervisor <u>DAS</u> <u>40</u> <u>9-89</u> <u>AUG 12 2020</u>	
Root Cause				FAULT CATEGORY				QC / QA Coordinator	
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☒ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:									